Work Orde				* -\ * <u>9</u> 4(Դ57*	. <u>.</u> . •		. •		Page 1
tem ID: Revision ID: tem Name:	D3915-041	semby, Long Basket		Accept	*N9(ากก4ก	100*	Setup	Start Stop	*NS1* *NS2*
	11/28/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust I Custor	tem ID: ner:				14(3)
Approvals:	Process Pl	an: _ M.US	Date: 12-12-0	Tooling: SPC (Y/N):		Date:	-	Run	Start Stop	*NR1* *NR2*
Sequence ID/ Work Center II		Operation Description	<u> </u>	Set Up/ Run Hours	Tool	JD Tool#	Plan Acc Code Qty			Reject Insp. Number Stamp
Draw Nbr		vision Nbr		1				_		
D3915 100 *1'\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\	C	Large Fab Memo 1- assemble D4019-3, w Then weld r with weld.	ribs , weld as per dwg Deld top and bottom then nemaining sides of D4019. OT WELD THE (4) CORNOR TO GET THE ACID AND	0.00 3915 using IDT9606A. W nake a small hole in the w -3 Rib. Let it cool down, to	veld to let air out. then block holes KNERS TO HAVE	Gl13	7.25	*	<i>.</i>	
*110 *110* QC		2- weld hing QC9- Inspect visual per Memo	ge, label plate and Mounti QS1004- Fusion Welds	ing plates as per dwg D39 0.00 0.00)15		1 x	(0As (09 -		H13.07.2
Quality Control				1						

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NCR:	/es	/ No				WORK ORDER NON-	COI	VFORM	MANCE / UP	DATE	04.01	Data	
-						1				_	QA Closed:	Date:	
Mark Ord	a					DISPOSITION			-	AGAINST D	EPARTMENT	/PROCESS	
Work Ord	21.					Rework	n I		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	do.					Scrap	1 1		Machining	Small Fab	- Pro	d. Eng. Coor.	Quality
, 4,						Use-as-is	1		noforming	Finishing	−	re/Packaging	Other
NCR 1	۷o.					Work Order Update]		Large Fab	Composite		Supplier	
<u>.</u>								L			.,	,	
Root						ption of work order update		nitial		tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data			•	Ì									
Equip/Tooling	Щ										1		
Operator	\Box		ļ ·										
Material					ļ								
Setup					[.								
Other													
Process									•				
Supplier	\Box				`	y s							
Training						* *							
Unapproved	1			<u> </u>				T CATE					
l andi:		`				General F	AUL	T CATE	GORY		·		
Landi	_	Bending				Bend		Grain			Ovalized	Г	Pressure/Forced
	-	Centre No	+ Cancar	.+-i-+-		BOM/Route	\vdash	Hardwa			Over/Under	toloranco	Temperature/Cure
	-	Cracks	it conter	itric to	^{0/3} -	Broken/Damaged	\vdash	4	on Incomplete	-	Part Incorre	⊢	Weld
		Crushed/0	*rimpad		-	Burrs	\vdash	1	ions Incomplete/	Lincloar	Part Lost/M	 	Wrong Stock Pulled
	$\overline{}$	Cuffs	mpeo		-	Contamination	-	Mainte	•		Part Moved	- <u>-</u>	
	\dashv	Heat Trea	t		ļ	Countersink		Mislabe		-	Positioned		
	\vdash	Inspection		Tuhe		Cut Too Short	-	Misread		}-	Power Loss	_	Other
	_	Ripples in				Drill Holes	\vdash	Offset	-	L	٠٠٠٠٠ الـــ		1
	\blacksquare	Torque W		xtrusio	n	Drawing	\vdash	-	Calibration				
		de			· · L	1		J · ·					

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

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NCR:	Yes / No				WORK ORDER NON-O	CON	IFORN	AANCE / UP	DATE	QA Closed:	Date:	
					DISPOSITION			<u> </u>	AGAINST DE	<u> </u>		
Work Ord	er:				Rework	, I		Skid-tube	Crosstube]	Water Jet	Engineering
Part I	No.				Scrap	11		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	1	Therm	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR I	No	····			Work Order Update]		Large Fab	Composite]	Supplier	
Root]		Descri	iption of work order update	Ir	nitial	Ac	tion	Sign &		<u> </u>
Cause	Date	Step	Qty		or Non-conformance	Chi	ef Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling		1				İ						
Operator			1 1			1						
Material												
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Process			1									
Supplier												
Training												
Unapproved	<u> </u>		<u> </u>							<u> </u>		<u> </u>
						AUL	CATE	GORY		<u> </u>		
Landi	ng Gear			r	General		Grain			Ovalized	<u> </u>	Pressure/Forced
	Bending			\(\rightarrow \ri	Bend BOM/Route	\vdash			-	Over/Under	taloranco	Temperature/Cure
		lot Conce	חנזוכ נס נ	^{7/3} -	Broken/Damaged	\vdash	Hardwa Incocsti	re on incomplete		Part Incorre	<u> </u>	Weld
ı	Cracks	/Crimped		-	Burrs	\vdash	-	on incomplete/ ions Incomplete/	Unclose	Part Lost/M	<u></u>	Wrong Stock Pulled
	Cuffs	Crimped		-	Contamination	-	Mainte		Officieal	Part Moved	2311.B	TANIOUR PLOCK LAUGA
	Heat Tre	at		\vdash	Countersink		Mislabe		 	Positioned V	Vrong	
		ar on Strip in	Tuhe	 	Cut Too Short	-	Misreac		 	Power Loss/		Other
	Ripples i	,	1006		Drill Holes	\vdash	Offset	•		J. 0.40, 2033/		10000
	 	Naves in I	Extrusion	, <u> </u>	Drawing	-		Calibration				
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Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Finish

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Work Orde				*94i	057*						Page 3
tem ID: Revision ID:	D3915-041	-	.== * =: -	Accept	*N900	040	100)* s	Setup Start	174.	S1*
	11/28/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:			Stop	^N;	S2*
Approvals:	Process Pla	in:	Date:	Tooling:	Da	ate:		F	Run Start		R1*
77,	QC:		Date:	SPC (Y/N):	Da	ate:			Stop	*N	R2*
Sequence ID/ Work Center II)	Operation Description QC9- Inspect visual per	OSI004- Fusion Welds	Set Up/ Run'Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control		Мето	•	0.00				_	13-08	~5∑ _	
55 *4 -*		QC6- Inspect dimensions	s to drawing	0.00					\ <u>}</u>		0A 00
* 1,55* QC Qualify Control		Мето		0.00					_6-0	60-G	<u>S</u> ∵€
Zuanty Comfor		***inspect f	it of lid with base***								
57 *157*		Chemical Conversion Co	oat per QSI005 4.1	0.00				1	He	13.8	B-/
HandFinish		Memo		0.00				/ _	<u> </u>	<u> </u>	· · —
Hand Finishing		1- realodine ***do not a									

												DQA:	Da	te:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	ANCE / UPI	DATE		QA Closed:	 Da	to.	
								1			_			ις.	<u> </u>
Work Ord	er:					DISPOSITION				AGAINST D	EF	PARTMENT,	/PROCESS		
Part I NCR I	No.					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root			Γ		Descri	ntion of work order update	П	Initial	Act	ion	Т	Sign &			
Cause		Date	Step	Qty	C	or Non-conformance	CH	nief Eng	Descr	iption		Date	Verificatio	n	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved															
	<u> </u>			·			FAUI	LT CATE	GORY		_				
Landi	ing G	iear				General		-							`
		Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio	Crimped at		1/5	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		4 '	on Incomplete ions Incomplete/U nance Ied	Inclear		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct issing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	П	Ripples in	Bend			Drill Holes		Offset		_	_	•			

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Work Orde				*94	.057*		Page 4
Item ID: Revision ID: Item Name:	D3915-041 Light Lid Asse	emby, Long Basket		Accept	*N900040100)* Setup Start	ומיאו
Start Date: Required Date: Reference:	11/28/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ID: Customer:		
Approvals:	Process Pla	in:	Date:	Tooling: SPC (Y/N):	Date:	Run Start Stop	"NRT"
Sequence ID/ Work Center II 160 *1'60* Powdercoat Powder Coating		2- Plug hold IST COAT START TIN OVEN TEN FINISH TIN 2ND COAT START TIN	corner with alodine only es prior to . ME: MPERATURE: ME: ME: ME: ME: ME: MPERATURE:	Set Up/ Run Hours 0.00 0.00 cccssary***********************************	,	Accept Reject Qty Qty	Reject Insp. Number Stamp 1-3/0-8/-07
170 *1.70* QC Quality Control		QC3- Inspect Part Finisl Memo	h	0.00		\ X	M13/08/07

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NCR:	/es / N	lo			WORK ORDER NON-C	ONFO	RMANCE / U	JPDATE			
									QA Closed:	Date:	
Work Orde	ar.				DISPOSITION			AGAINST	DEPARTMENT,	PROCESS	
WORK Orde	=				Rework		Skid-tube	Crosstube	- 7	Water Jet	Engineering
Part N	lo				Scrap		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
NCR N	lo				Use-as-is Work Order Update	The	ermoforming Large Fab	Finishing Composite		re/Packaging Supplier	Other
Root				Descri	ption of work order update	Initia	1	Action	Sign &		
Cause	Dat	e Step	Qty		or Non-conformance	Chief E	ng D	escription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling		ŀ							İ		
Operator											
Material		İ					•				
Setup					·						1
Other			1.		•					:	
Process											
Supplier							İ				
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Unapproved											
					F/	AULT CA	TEGORY				
Landi	ng Gear				General	_				_	-
	Bendi	ng		<u> </u>	Bend	Grai	n		Ovalized		Pressure/Forced
	Centr	e Not Conce	ntric to	o/s	BOM/Route	Hard	lware		Over/Under	tolerance	Temperature/Cure
	Crack	5			Broken/Damaged	Insp	ection Incomplet	e	Part Incorre	ct	Weld
	Crush	ed/Crimped	•	<u> </u>	Burrs	Instr	uctions Incomple	ete/Unclear	Part Lost/M	ssing	Wrong Stock Pulled
	Cuffs	}			Contamination	∐ Mai	ntenance		Part Moved		
	Heat	rreat			Countersink	Misl	abeled		Positioned V	Vrong	_
	Inspe	ction Strip in	1 Tube		Cut Too Short	Misr	ead		Power Loss/	Surge	Other
	Ripple	s in Bend			Drill Holes	Offs	et				
	Torqu	e Waves in	Extrusio	n 「	Drawing	Out	of Calibration				

Outside Dimensions

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Finish

Work Order ID November-30-12 8:29:		<u>*</u> 92	1057*	Page 5
Item ID: D3915 Revision ID: Item Name: Light L	5-041 Lid Assemby, Long Basket	Accept	*N900040100°	Setup Start *NS1* Stop *NS2*
Start Date: 11/28/ Required Date: 12/14/ Reference:	~ •	*1* *1*	Cust Item ID: Customer:	/
Approvals: Proce		te: Tooling:	Date: Date:	Run Start *NR1* Stop *NR2*
Sequence ID/ Work Center ID 180 *180* HandFinish	Operation Description Assemble as per dwg	Set Up/ Run Hour 0.00		Accept Reject Reject Insp. Oty Oty Number Stamp
Hand Finishing 190 *100* QC Quality Control	I- Install webbing 2- Install placard a QC5- Inspect part completenes Memo	nd label as per dwg	-	DAS 05 13.08.00
200 *200* Packaging Packaging	ldentify as per dwg & Stock L Memo	ocation: 0.00 0.00) 4030-045/B94092	

												DQA:	Da	te:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORN	/IANCE / UP	DATE					•
									··		_	QA Closed:	Da	te:	
Work Ord	or:		- -			DISPOSITION				AGAINST D	EF	PARTMENT	PROCESS		
Work Ord	C1.					Rework	7		Skid-tube	Crosstube	٦		Water Jet		Engineering
Part I	No.					Scrap	7		Machining	Small Fab	1	Pro	d. Eng. Coor.		Quality
	,					Use-as-is		Therm	noforming	Finishing		Rec/Stor	e/Packaging	-	Other
NCR I	No.					Work Order Update	ال		Large Fab	Composite			Supplier		
Root					Descri	ption of work order update		Initial	Ac	tion		Sign &			
Cause		Date	Step	Qty	C	or Non-conformance	Ct	nief Eng	Desc	ription		Date	Verificatio	n	QC Inspector
Doc/Data													II.		
Equip/Tooling															
Operator	Ш		1				İ								
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Other															
Process															
Supplier								1							
Training															
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Landi	ng (Gear			_	General	_	_		_					-
		Bending				Bend		Grain				Ovalized		\perp	Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re			Over/Under	tolerance	L	Temperature/Cure
		Cracks				Broken/Damaged	L	Inspecti	on Incomplete			Part Incorre	ct	L	Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/	/Unclear		Part Lost/Mi	ssing	\mathbb{L}	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance			Part Moved			
		Heat Trea	at .			Countersink		Mislabe	led			Positioned V	Vrong		-
		Inspectio	n Strip in	Tube	Γ	Cut Too Short		Misread	I			Power Loss/	Surge		Other
	ſ.	Ripples in	Bend			Drill Holes		Offset		_					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord			? ?	*94057*								Page 6		
Item ID: Revision ID: Item Name:	D3915-041 Light Lid As	semby, Long Basket	- :	Accept	<u></u>	*N900	ก4ก	100)* 	Setup	Start Stop	1.7	S1* S2*	
Start Date: Required Date Reference:	11/28/12 : 12/14/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*			Cust Item II Customer:	D:			Run				
Approvals:	Process P	an:	Date:	Toolin	ì		Date:				Start Stop	1/1	R1* R2*	
Sequence ID/ Work Center I 210 *210* QC Quality Control	· D	Operation Description QC21- Final Inspection Memo	- Work Order Release		Up/ n Hours	Tool ID	Tool#	Plan Code		t Re Qt	y 13	Reject Number	Insp. Stamp	

Work Order: Part No. NCR No. Wo			DQA:	Date:	<u> </u>
Part No Wo	K ORDER NON-CONFORM	IANCE / UPDATE	QA Closed:	Date:	
Part No Wo	DISPOSITION	AGAINST D	EPARTMENT		
المارة في المارة المارة المارة المارة المارة المارة المارة المارة المارة المارة المارة المارة المارة المارة ال	Rework Scrap N Use-as-is Therm ork Order Update		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root Description of w	vork order update Initial	Action	Sign &	-	<u> </u>
Cause Date Step Qty or Non-co	informance Chief Eng	Description	Date_	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved	FAULT CATEG	CORV		·	
Landing Coas	General	OCKY	<u> </u>		
Bending Bend Centre Not Concentric to O/S BOM/Ro	Grain Hardwar Damaged Inspection Instruction Sink Mislabel	on Incomplete ons Incomplete/Unclear nance	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V	ct	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Finish

Work Order ID:

94057

Parent Item:

D3915-041

Parent Item Name: Light Lid Assemby, Long Basket

Start Date: 11/28/12

Required Date: 12/14/12

Page 1

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ tem Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Statu
2957 Jounting Plate		Manufactured	No	- · 		100	Each	8.0000	4	4	CPCI	<u>3·7</u>	25
•				<u>Location</u>		Loc Oty	L	oc Code	Ę	2 #5	3941	6b-	-
1				WA004		8					, ,,		(
1				848:		2							
				877:	53	6			-		// _		_
915-1		Manufactured	No]	100	Each	5.0000	2	2 (PLI	3・フ-	25
, ']						7	_	
1				<u>Location</u>	Ì	Loc Qty	<u>[</u>	oc Code		Ξ	B 940	99-	
•				WA005	ŀ	5							
				870		4					1 ,		
1016-5			No	881	32	100	Each	17.0000	3	//	\mathcal{D}		
nge Half, Light Lid		Manufactured	NO		1	100	Cacir	17.0000	3	7	1/13	10	ク
ige Hait, Eight Eid				Location		Loc Qty		oc Code		7	3911~		/
				WA004			Ŧ	<u>we coue</u>		4	170	//	
ı				W AU04 874	70 !	17 14							
1				880		3			-		\triangle		
4019 - 3		Manufactured	No			100	Each	7.0000	3	3			~ .
ь		mananaciarea			!						_LpC,	<u> 13:7:</u>	25
1				Location	1	Loc Oty	L	oc Code			794	1113=	-
				WA005	i	. 7	_				/ /	11-	
				883	40	7							_
4029-041		Manufactured	No		ı	180	Each	3.0000	1	1	a .	. 0	//
ebbing (Long Basket)		, Iuilaidotalea									744.8	2_0	1/_/

Location Loc Qty Loc Code ST489 88283 3

					•					DQA:	Date:	
NCR:	Yes /	No			WORK ORDER NON-CONFORMANCE / UPDATE				-		<u>₹</u> • ₹	
	<u>.</u>									QA Closed:	Date:	
Work Order: Part No. NCR No.					DISPOSITION	-	AGAINST DEPARTMENT/PROCESS					
					Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite		Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other	
Root			<u> </u>	Descri	ption of work order update		nitial	Ac	tion	Sign &		
Cause	Da	ite Ste	p Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved			\		E	A111	T CATE	CORV				
Landi	ing Gear				General	MUL	I CATE	3001				
•	Bence Cente Crace Crusi Cuffs - Heat	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs - Heat Treat Inspection Strip in Tube Ripples in Bend			Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		•	on Incomplete ions Incomplete/ enance eled	'Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned N	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Torq	ue Waves	n Extrusio	on [Drawing		Out of C	Calibration				

Outside Dimensions

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Finish

Manamban	20 12	8:29:32 AM
November-	30-12	6:29:32 AM

Work Order 1D:

94057

Parent Item:

D3915-041

Pagent Item Name:

Light Lid Assemby, Long Basket

D4035-045

Lid Rib Assembly, Fwd (Light)

Manufactured

No

Location WA005

89089

D4035-047 Lid Rib Assembly, Aft (Light)

D4056-1

Label Plate

Manufactured

No

Location WA005

89236

Location WA004

No Manufactured

No Purchased

Location

\$1311

WA003

111636 117601 118626

85016 87247

120308 122151

123525

107939 122452

Start Date: 11/28/12

Required Date: 12/14/12 Required Qty: 1.00

Start Qty: 1.00

5.0000

Loc Code

Each 4.0000

Each

Loc Code

26.0000 Each

Loc Qtv Loc Code 26 22

100

100

100

180

Loc Qty

1130

36

3 200

232

205

454

269 133

136

Loc Oty

Loc Qty

5

Each

1,399,0000

Loc Code

November-30-12 8:29:32 AM

Shop Packet Print

Page 2

NCR: Yes / No

Work Order:

Part No.

NCR No.

WORK ORDER NON-CONFORMANCE / UPDATE

Skid-tube

Machining

Large Fab

Thermoforming

Crosstube

Small Fab

Finishing

Composite

DISPOSITION

Work Order Update

Rework

Scrap Use-as-is

	DQA:	Date:		
TE				_
	QA Closed:	Date:		4
AGAINST	DEPARTMENT/	PROCESS		
Crosstube Small Fab			Engineering Quality	
Small Fabi	l Prod	Eng Coor	Ouality! 1 1	

Rec/Store/Packaging

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-607-2 REV. C AND EARLIER, INSTALLATION INSTRUCTIONS D350-607-3 REV. A AND EARLIER, AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-607 REV. 4 AND EARLIER

REF. TCCA STC; SH94-14 REF. FAA STC; SR00213NY REF. EASA STC; EASA.10016998

REF. ANAC STC'S: 2007S03-03/-04/-05/-06

1.0 PURPOSE:

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It has come to DART's attention that the webbing strands of the cargo net riveted to the structure of the lightweight lids on D350-607-443/-447/-543/-547 Heli-Utility-Baskets at CHG 004 and earlier may pull through the small washer and rivet head and detach during operation.

The purpose of this service instruction is to provide parts and instructions to replace the NAS1149DN416J Washers and MS20600AD4W3 Rivets fastening the webbing strands of the cargo net onto the structure of the lightweight lids with NAS1149DN949J Washers and MS20600AD4W4 Rivets.

Note: This change has been incorporated at a manufacturing level on D350-607-443/-447/-543/-647 Hell-Utility-Baskets at CHG 005 and subsequent and on D350-807-417/-419 Lightweight Lid Kits at CHG 003 and subsequent.

2.0 PROCEDURE:

- 2.1 Carefully remove existing rivets and washers attaching the webbing to the lid frame without enlarging holes in the webbing or the lid frame.
- 2.2 Inspect the basket lid structure in accordance with ICA-D350-607. It is acceptable to inject Sikaflex -241/-291 or Proseal 890 or MIL-S-8802 Class B2 sealant into the lid structure to trap rivet debris inside the tubular structure. Repair and touch up finish as required.
- 2.3 Inspect the D4029-041 Webbing (long basket) or D4029-043 Webbing (short basket) for wear. The maximum acceptable hole size is 20.188" (4.8 mm). Replace the webbing if holes are larger than
- - Ø0.188" (4.8 mm) or if the webbling is worn or cuts have been found.
- 2.4 Re-install the webbing as shown in Figure 1 of this service instruction
 <u>Note:</u> It is acceptable to upsize rivets to MS20600AD5W4 (customer supplied) and enlarge the holes in the basket lid structure to Ø0.156" (3.96 mm) if holes were enlarged at Step 2.1.

3.0 PARTS LIST

QTY -011	QTY -013	PART NUMBER	DESCRIPTION
X		DSI 9657-011	WASHER CHANGE (LONG LID)
	X	DSI 9657-013	WASHER CHANGE (SHORT LID)
34	30	MS20600AD4W4	BLIND RIVET
34	30	NAS1149DN949J	WASHER

DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-0-01

APPROVED

BY:
D. SHEPHERD (DE # 02)

DATE:
13.08.06
CERT. NO.:
ISSUE NO.:
5

CANADA

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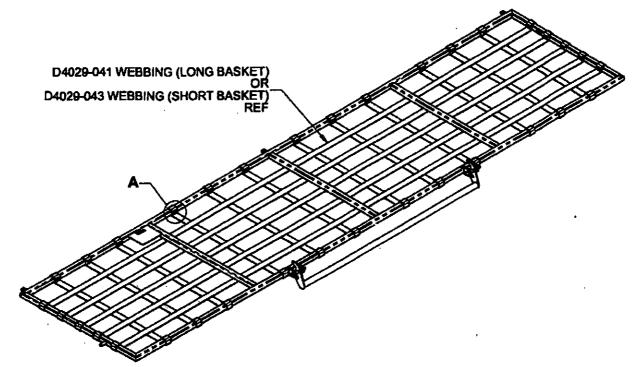
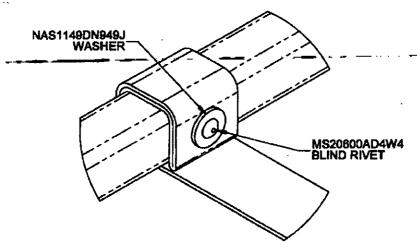


FIGURE 1: D3915-041 LONG BASKET LID ASSY (LIGHT WEIGHT) D4019-041 SHORT BASKET LID ASSY (LIGHT WEIGHT)



DETAIL A: RIVET/WASHER REPLACEMENT 34 PL ON D3915-041, 30 PL ON D4019-041

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-0-01

APPROVED

D. SHEPHERD (DE # 02)

DATE: 13.06.06
CERT. NO.: \$H94-14
ISSUE NO.: 5

DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A **DSI 9657** MFG. APPR. SHEET 2 OF 2 TITLE APPROVED SCALE WASHER CHANGE DE APPR. COPYRIGHT © 2013 BY DART AEROSPACE LTD
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